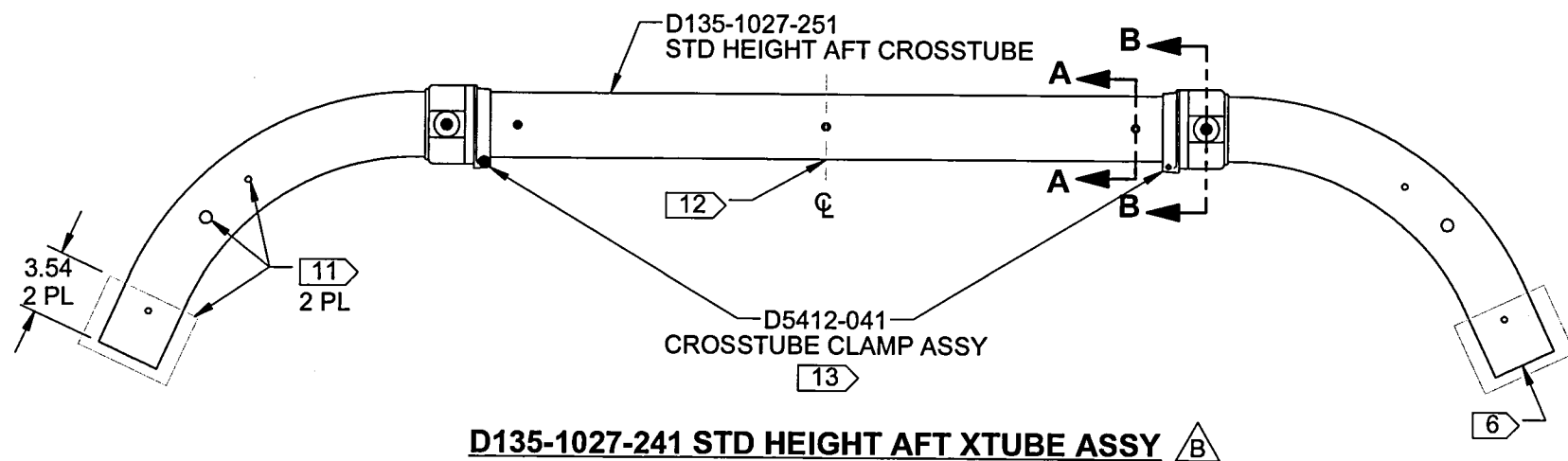
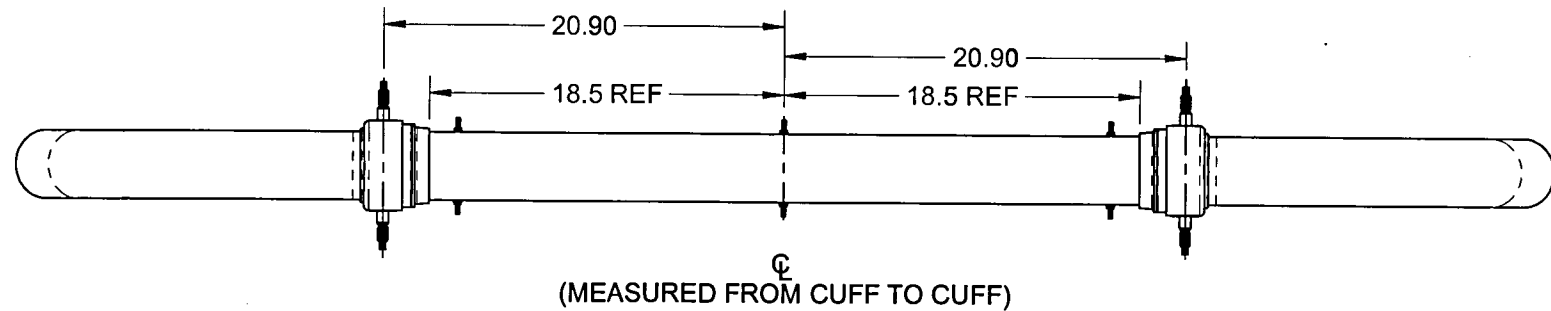
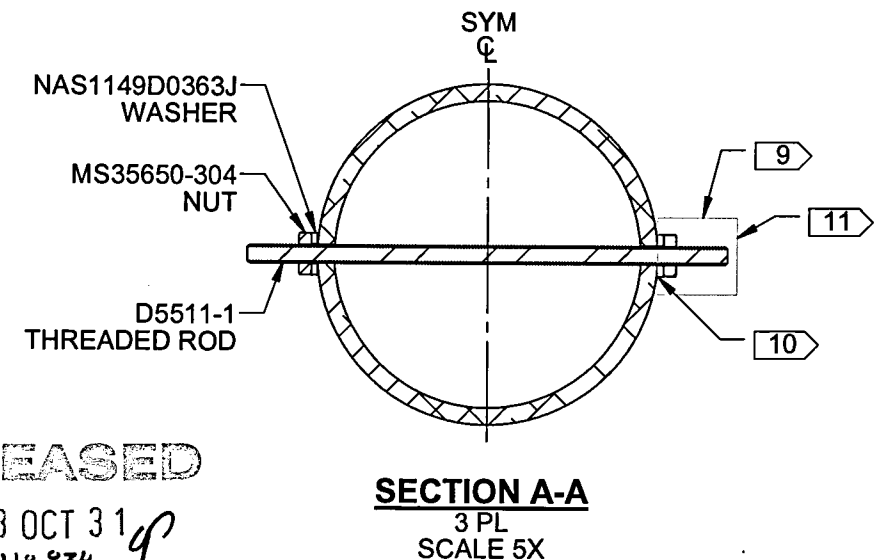
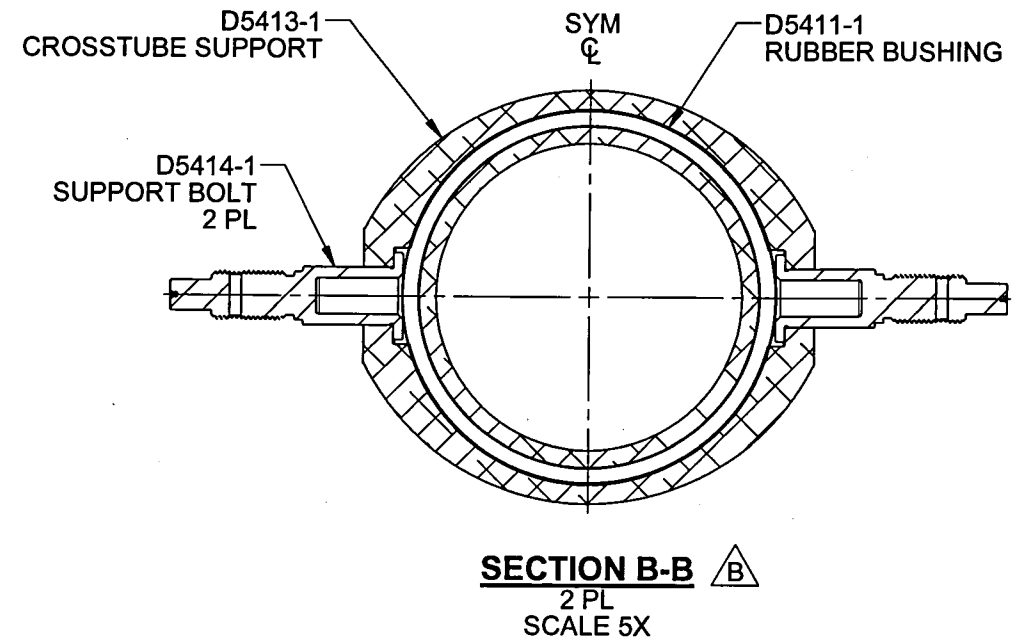


QTY -241	P/N	DESCRIPTION
X	D135-1027-241	STD HEIGHT AFT XTUBE ASSY
1	D135-1027-251	STD HEIGHT AFT CROSSTUBE
2	D5411-1	RUBBER BUSHING
2	D5412-041	CROSSTUBE CLAMP ASSY
2	D5413-1	CROSSTUBE SUPPORT
4	D5414-1	SUPPORT BOLT
3	D5511-1	THREADED ROD
6	MS35650-304	NUT
6	NAS1149D0363J	WASHER



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT BARE TUBE PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PRIOR TO SUPPORT INSTALLATION PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
PAINT OUTSIDE PRIOR TO SUPPORT INSTALLATION PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: SCRIBE DART P/N "D135-1027-241" AND B/N ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS)
 - 7) WEIGHT: 20.24 LBS
 - 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE.
 - 9) PRIOR TO PRIME AND PAINT, APPLY 1 DROP OF LOCKTITE 263 TO THE MATING THREADS OF D5511-1 IMMEDIATELY PRIOR TO INSTALLING AND TORQUING THE MS35650-304 NUT TO 5-10 IN-LBS
 - 10) PRIOR TO PRIME AND PAINT, FILLET SEAL USING PR1422 B1/2 OR P/S-890 B1/2 SEALANT
 - 11) MASK PRIOR TO PRIME AND PAINT
 - 12) AFTER FINISHING MARK THE ENTIRE CIRCUMFERENCE OF THE CROSSTUBE CENTERLINE (± 0.1 " PER QSI 044 6.1
 - 13) PRESS D5412-041 CROSSTUBE CLAMP TIGHT AGAINST D5411-1 RUBBER BUSHING THEN TORQUE BOLT TO 50-70 IN-LBS
 - 14) IT IS ACCEPTABLE TO USE MILD SOAP AND WATER OR A SMALL AMOUNT OF WATER BASED LUBRICANT TO INSTALL THE SUPPORTS



RELEASED
2018 OCT 31
ECN 18-834

B	ADDED D5411-1, D5412-041, D5413-1, AND D5414-1 REVISED NOTES, ADDED SECTION B-B	ZF	18.10.04
A	NEW ISSUE	AJS	17.07.13
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MW	DRAWING NO.	REV. B
MFG. APPR.	DD	D135-1027-241	SHEET 1 OF 1
APPROVED	NO	TITLE	SCALE
DE APPR.	CP <i>op</i>	STD HEIGHT AFT XTUBE ASSY	NTS
DATE	18.10.04	COPYRIGHT © 2017 BY DART AEROSPACE LTD	
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